

Report

Work Order ID 144318

144318

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Tuesday, April 26, 2016 3:39:13 PM

Item ID: 647.3901 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Lower Deflector Assembly, Low
Start Date: 4/18/2016 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 5/2/2016 Req'd Qty: 1.00 *1* Customer:
Reference:

Approvals: Process Plan: MUF Date: 16-4-26 Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.3900	C2								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120		0.00							
120									
Small Fab	Memo	0.00							
Small Fab	Assemble as per dwg and apply loctite 598 on all faying surfaces per note.								
	A/R RTV LOCTITE 598: <u>134524</u>								
	exp. date: <u>09/17</u>								
130	QC5- Inspect part completeness to step on W/O	0.00							
130									
QC	Memo	0.00							
Quality Control									

DAS
38
9-89
MAY 02 2016

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Item ID: 647.3901

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Deflector Assembly, Low

Start Date: 4/18/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 5/2/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Identify as per dwg & Stock Location: <u>GA</u>	0.00				<u>K</u>			<u>16/05/03</u>
140									
Packaging	Memo	0.00							
Packaging	***IDENTIFY AS PER IAW MPP-120***								
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

MCS MAY 03 2016MCS MAY 03 2016

Picklist Print

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Work Order ID: 144318

144318

Parent Item: 647.3901

647 3901

Parent Item Name: Lower Deflector Assembly, Low

Start Date: 4/18/2016

Required Date: 5/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.09.03 NEW ISSUE DD VERF:JLM

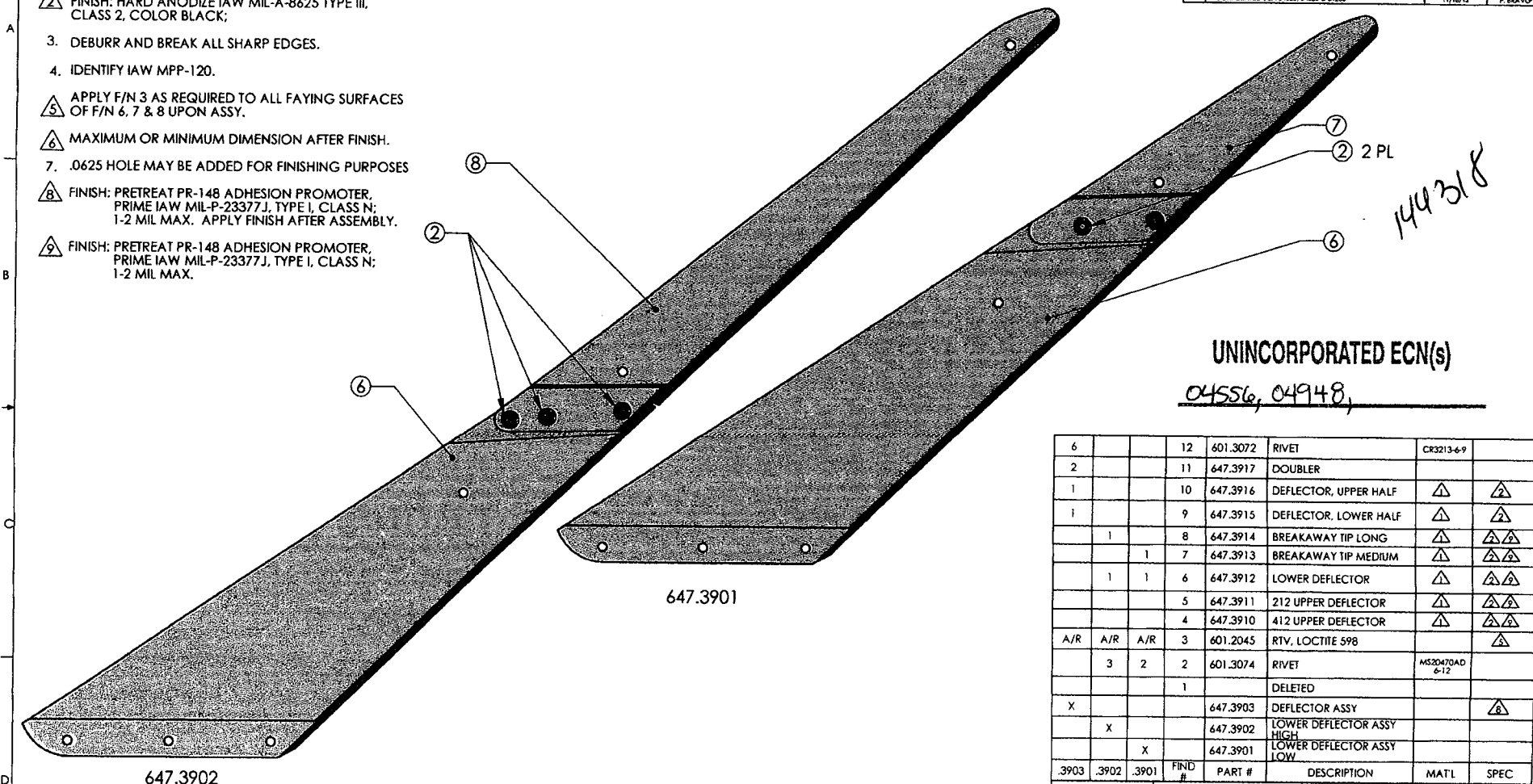
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.3912 *647 3912* Lower Deflector		Manufactured	No				Each	19.0000	**	1	DAS 30 9-89		MAY 02 2016
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				CCK077			19						
				124409			3						
				127896			10						
				131075			6						
647.3913 *647 3913* Breakaway Tip Medium		Manufactured	No				Each	12.0000	**	1	DAS 30 9-89		MAY 02 2016
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				cck111			12						
				123518			5						
				124488			7						
MS20470AD6-12 *MS20470AD6-12* Rivet		Purchased	No				Each	137.0000	**	2	DAS 30 9-89		MAY 02 2016
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST308			137						
				m127304			137						

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NOTES:

- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12.
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK;
3. DEBURR AND BREAK ALL SHARP EDGES.
4. IDENTIFY IAW MPP-120.
- 5 APPLY F/N 3 AS REQUIRED TO ALL FAYING SURFACES OF F/N 6, 7 & 8 UPON ASSY.
- 6 MAXIMUM OR MINIMUM DIMENSION AFTER FINISH.
7. .0625 HOLE MAY BE ADDED FOR FINISHING PURPOSES
- 8 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377 J, TYPE I, CLASS N; 1-2 MIL MAX. APPLY FINISH AFTER ASSEMBLY.
- 9 FINISH: PRETREAT PR-148 ADHESION PROMOTER, PRIME IAW MIL-P-23377 J, TYPE I, CLASS N; 1-2 MIL MAX.

REVISIONS			
REV.	DESCRIPTION	DATE	APPROVED
	LAST PROTOTYPE RELEASE: P81		N/C
N/C	INITIAL RELEASE	09/10/09	P. BRAVO
A	INCORPORATED ECN 02864, 03539 & 03593	07/24/12	P. BRAVO
B	INCORPORATED ECN 04025	08/02/13	P. BRAVO
C	INCORPORATED ECN 04038, 04085 & 04250	11/18/13	P. BRAVO



UNINCORPORATED ECN(s)

04556, 04948,

6			12	601.3072	RIVET	CR3213-6-9	
2			11	647.3917	DOUBLER		
1			10	647.3916	DEFLECTOR, UPPER HALF	△	△
1			9	647.3915	DEFLECTOR, LOWER HALF	△	△
	1		8	647.3914	BREAKAWAY TIP LONG	△	△
		1	7	647.3913	BREAKAWAY TIP MEDIUM	△	△
	1	1	6	647.3912	LOWER DEFLECTOR	△	△
			5	647.3911	212 UPPER DEFLECTOR	△	△
			4	647.3910	412 UPPER DEFLECTOR	△	△
A/R	A/R	A/R	3	601.2045	RTV, LOCTITE 598		△
	3	2	2	601.3074	RIVET	MS20470AD 6-12	
			1		DELETED		
X				647.3903	DEFLECTOR ASSY		△
	X			647.3902	LOWER DEFLECTOR ASSY		
		X		647.3901	LOWER DEFLECTOR ASSY		
					LOW		
.3903	.3902	.3901	FIND #	PART #	DESCRIPTION	MATL	SPEC

PARTS LIST			
QTY	DESCRIPTION	DATE	REVISION
	NEXT ASSY (S)	09-10-09	
647.3800	DRAWN BY: D.SCHUR	CHECKER: D.BARKER	
	DRAWING APPROVAL: P. BRAVO	DATE: 09-10-09	
	CONTRACT NO.		
	UNLESS OTHERWISE SPECIFIED		
	DIMENSIONS ARE IN INCHES		
	TOLERANCES ARE:		
	2 PLACE DECIMALS ±.01		
	3 PLACE DECIMALS ±.005		
	ANGLES ± .5°		
APICAL INDUSTRIES			
2608 TEMPLE HEIGHTS DR.			
OCEANSIDE, CA. 92056-3512 (760)724-5300			
DEFLECTORS			
SHEET	CAGE CODE	DWG. NO.	REV.
B	07M16	647.3900	C
SCALE NONE		SHEET 1 OF 12	